



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D412-742-043
Job Sheet 187412



Part No: D412-742-043

Job Qty: 1 ea

Part Name: Repl. Skidtube Fits LH or RH, High Gear, DART (Apical) Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/4/18

Job Tracking No:

Due Date: 1/29/19

Created By: Jesse White

Type: Stock

Description:

Note: DWG D3391-043 REV J SHEETS 1,2 IPP Rev A 05.10.13 New Issue KJ/JLM IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC IPP Rev:C 07-05-28 As per Rev F JLM IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:F 11.11.01 as per DSI9517 REV.B DD verified by:EC IPP REV:G 16.05.02 AS PER DWG REV.J DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/29/19	0.00	0.00	Start Up Container		N/A
110	HandFinish	1 pcs		1/29/19	0.00	3.50	HandFinish4		14-12-9
120	QC	1 pcs		1/29/19	0.00	0.00	QC5		JUN 10 2019 68
130	Packaging	1 pcs		1/29/19	0.00	0.00	Packaging3-2		9-89
135	DC	1 pcs		1/29/19	0.00	0.00	DC	DAS 21	DAS 28
140	QC21-FG	1 Ea		1/29/19	0.00	0.00	QC21	21	28 JUN 13 2019

Part Op 110 - 1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with Descriptions: saddle holes for proper alignment. using 7/16" "T" Pins. A/R Sikaflex-241/291 5163437 Expiry date: 14-12-9 2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex. A/R Sikaflex-241/291 5163437 Expiry date: 14-12-9 3-Remove "T" pins once sikaflex is dry. 4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/R LPS Procyon M133640 VERIFY FWD AND AFT SADDLE FIT DURING ASSEMBLY BY: SL DATE: 19/06/11

130 - Identify and pack for shipping as per PPP D412-742-043 Location: _____ PPP Rev: _____

135 - If D412-742-043 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-742-043 CHG007

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C4A	Bolt	24 Ea (24 ea)	90-Start up Operation	5143675
AN3C6A	Bolt	4 Ea (4 ea)	90-Start up Operation	5174235
AN5C7A	Bolt	10 Ea (10 ea)	90-Start up Operation	5079115
D3391-021	Fwd Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5136679
D3391-023	Mid Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5137167
D3391-025	Aft Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5155246
D4095-041	Wearplate Fwd	1 Ea (1 ea)	90-Start up Operation	5072731
D4095-043	Wearplate Aft	1 Ea (1 ea)	90-Start up Operation	5059995
D4095-045	Wearplate Center	1 Ea (1 ea)	90-Start up Operation	5041625
NAS1149C0332R	Washer	28 Ea (28 ea)	90-Start up Operation	5158078
NAS1149C0532R	Washer	10 Ea (10 ea)	90-Start up Operation	5014735

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) _____	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C4A	24	1,647	0
	AN3C6A	4	159	0
	AN5C7A	10	144	0
	D3391-021	1	2	0
	D3391-023	1	2	0
	D3391-025	1	4	0
	D4095-041	1	12	0
	D4095-043	1	12	0
	D4095-045	1	9	0
	NAS1149C0332R	28	3,437	0
	NAS1149C0532R	10	402	0

Part Specifications

Specifications could not be found.

Plex 12/4/18 10:32 AM dart.white.jesse

DART
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Hawkesbury, ON K6A 1K7
CANADA
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Email: sales@dartaero.com
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Container No: S189059



Part: D412-742-043

Job No: 187412

Serial No/Batch: S189059

Revision: A/J

Inspector:

Exp Date:

Instructions: FAA STC SR01583SE 18/10/17 TC STC SH05-

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

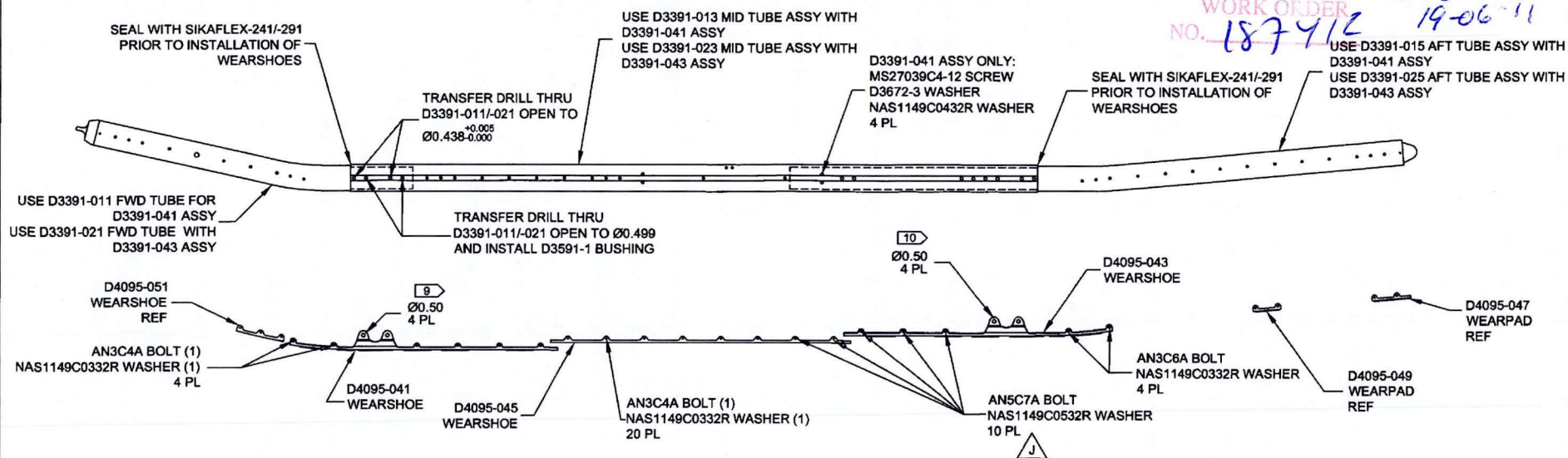
Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) ☐	
Description Work Order Deviation		Disposition		Completed By	
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				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 187412

145
19-06-11



D3391-041/-043 ASSY



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3
PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.6
- 7) WEIGHT: N/A
- 8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
- 9) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL $\varnothing 0.50$ HOLES FROM SADDLE TO D4095-041
- 10) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL $\varnothing 0.50$ HOLES FROM SADDLE TO D4095-043

RELEASED
2016-04-28

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	DP	D3391	SHEET 2 OF 11
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	412 FLOAT SKIDTUBE	NTS
DATE	16.01.14	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
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Entered: _____ Date: _____



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